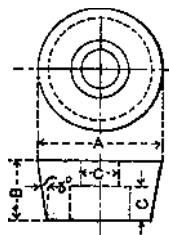


## OPEN DRILL JIGS

with a clamping strap which can be pulled back for removing and inserting the work. Instead of having the legs solid with the jig, as shown in Fig. 8, loose legs, screwed in place, are sometimes used, as shown in Fig. 9.

These legs are round and provided with a shoulder *A*, preventing them from screwing into the jig-plate. A headless screw or pin through the edge of the circumference of the threads at the top prevents the studs from becoming loose. These loose legs are usually made of machine steel or tool steel, the bottom end

### Standard Jig Feet



*H*            *Ha H*  
*Me H*        *Ha*  
               *Me*

5/11

W\* Ha

K

Mo

*Hz*

Mfl

### Screws for Jig Feet

<i>J\$.</i>		<i>A</i>	<i>B</i>	<i>C</i>	<i>D</i>	<i>A</i>	<i>JB</i>	<i>C</i>	<i>D</i>
<i>N</i>	<i>Pu</i>	0.160	<i>H</i>	0.110	<i>Ha</i>	0.299	<i>Ha</i>	0.192	<i>Me</i>
<i>u</i>	<i>A-J</i>	0.191	%4	0.123	<i>Me</i>	0.343	<i>H</i>	0.219	<i>1^2</i>
<i>h n</i>	<i>•T'''</i>	0.213	<i>Ha</i>	0.137	<i>*Mh</i>	0.386	9&	0.246	<i>H</i>
<i>h n</i>	<i>---</i>	0.233	<i>W4</i>	0.150	<i>H</i>	0.426	<i>He</i>	0.273	<i>h&gt;iz</i>
<i>h n</i>	<i>---</i>	0.256	5/16	0.164	<i>ia^2</i>				

being hardened and then ground and lapped, so that all four legs are of the same length. It is the practice of many tool-makers not to thread the legs into the jig body, but simply to provide a plain surface on the end of the leg, which enters into the jig-plate, and is driven into place. This is much easier, and there is no reason why, for almost all kinds of work, jigs provided with legs attached in this manner should not be equally durable.

Jig feet are also made of the form shown in the accompanying table, where a separate screw is used for holding the jig feet to the jig body.

When jigs are made of machine or tool steel, and feet are